Work Ord August-28-13		5168		*10F	3168*							Page 1	_
Item ID: Revision ID:	D3912-5			Accept	*N900	040	100)*	Setup		*N	S1*	=
Item Name:	Eyebolt Plate									Stop	*N:	S2*	
Start Date: Required Date: Reference:	8/28/13 : 8/28/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item l Customer:	ID:							
Approvals:	Process Plan	n:	Date: \\\ _ _ _ _ _ _ _ _ _ _ _ _	Tooling: SPC (Y/N):		ate:				Start Stop		R1* R2*	
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		leject lumber	Insp. Stamp	
Draw Nbr	Revi	sion Nbr											
D3912	В	j											
*100 *100* Waterjet FLOW CNC Water 304./25*	jet	Memo Cut.as per Prog Rev: Dwg Rev:		0.00				8	c	.	•	JM13-1	1-5
*110 *110* QC		Deburr as QC2- Inspect parts off Memo	•	0.00-				_8	_0			<u>Jm3-11</u>	-5

Quality Control

										*	DQA	\:Da	ate:		
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE	0.4.01				
											QA Closed	d: Da	ate:		
Work Ord	er.					DISPOSITION				AGAINST DE	EPARTMENT/PROCESS				
	٠					Rework	7	l	Skid-tube Crosstube			Water Je	·	Engineering	
Part I	۷o.					Scrap	1		Machining	Small Fab	l Pr	od. Eng. Coor	\vdash	Quality	
	•					Use-as-is	7		noforming	Finishing	4	ore/Packaging	-	Other	
NCR I	No.					Work Order Update	1		Large Fab	Composite		Supplier	\vdash	H	
	•					<u> </u>	_				.d				
Root					Descri	ption of work order update		Initial	Acti	ion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descri	iption	Date	Verification	on	QC Inspector	
Doc/Data															
Equip/Tooling							i								
Operator							ŀ								
Material	Ш														
Setup	\bigsqcup										1				
Other															
Process						•									
Supplier			•												
Training															
Unapproved												<u> </u>		·	
							FAUI	LT CATE	GORY						
Land	ing (1			_	General		-			7			ı	
	<u> </u>	Bending			<u> </u>	Bend	_	Grain		_	Ovalized			Pressure/Forced	
	L	Centre Not Concentric to O/S				BOM/Route	\perp	Hardwa			-1	er tolerance		Temperature/Cure	
	Cracks					Broken/Damaged	L	- 1 '	on Incomplete	<u></u>	Part Incorr		-	Weld	
	Crushed/Crimped					Burrs	_	4	ions Incomplete/U	Inclear	Part Lost/i	-		Wrong Stock Pulled	
		Cuffs				Contamination		Mainte			Part Move				
	\vdash	Heat Tre	at			Countersink		Mislabe	eled		Positioned	•		ı	
		Inspection	pection Strip in Tube			Cut Too Short		Misread	Misread			s/Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord		06168			*10616	38*		- :,				Page
August-28-13 Item ID: Revision ID: Item Name:				Accept *	1 900	<u>040</u>	100)*	Setup Sta	1.7	S1* S2*	
Start Date: Required Date Reference:	8/28/13 e: 8/28/13	Start Qty: 8.00 Req'd Qty: 8.00		*8* *8*		Cust Item 1 Customer:	D:					
Approvals:	pprovals: Process Plan: Da QC: Da				Tooling: SPC (Y/N):	Date: Date:			F	Run Sta Sto	I/I	R1* R2*
Sequence ID/ Work Center 120 *120* QC Quality Control	lD	Operation Description QC8- Inspect parts - seco	nd check		Set Up/ Run Hours 0.00 DAS 27 0.00 989	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Locatio	n: <u>57144</u>	0.00				_8x	DAS 28 9-89	3 <u>-//</u>	-5

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

*14**0***

Quality Control

Rm 13/11/07.

MF 13/11/07

Page 2

											DQA:	Da [,]	te:	
NCR: Y	es / No				WORK ORDER NON-O	CON	IFORN	MANCE / UP	DATE					
											QA Closed:	Da	te:	
Work Orde	, č ·				DISPOSITION	İ	AGAINST DEPARTMENT/PROCESS							
WOIR OIGE					Rework	1		Skid-tube	Crosstube		Water Jet			Engineering
Part N	lo.				Scrap								\Box	Quality
			·		Use-as-is	1		oforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo				Work Order Update]		Large Fab	Composite]	Supplier		
Root				Descri	ption of work order update		nitial	Ac	tion		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data														
Equip/Tooling						Ì							ŀ	
Operator														
Material														
Setup		1				1								
Other														
Process														
Supplier														
Training														
Unapproved														
					F	AUL	T CATE	GORY						
Landir	ng Gear				General						_	i		
	Bending				Bend		Grain				Ovalized			Pressure/Forced
	Centre N	ot Conce	ntric to	o/s [_	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on incomplete			Part Incorred	:t		Weld
	Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance			Part Moved	,		
ĺ	Heat Tre	at		Γ	Countersink		Mislabe	led			Positioned V	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short		Misread	l			Power Loss/	Surge		Other
	Inspection Strip in Tube Ripples in Bend				Drill Holes		Offset				_	'		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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Page 1

Work Order ID: 106168

106168

Parent Item:

D3912-5

D3912-5

Parent Item Name: Eyebolt Plate

Start Date: 8/28/13

126075

Required Date: 8/28/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP RevA: new issue DD 09.11.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304S11GA		Purchased	No			100	sf	285.6933	0.05125	Q.4 315	79-	
M304S1 1 304/316 0.125 Sheet	IGA								**		0.5	Jm13-11-5
				Location		Loc (<u>Oty</u>	Loc Code				
				MAT020		285.6932	2632		_			
					122521	19.1432	2632				_	
					124445	9	2.54					

M126075

174.01

•									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-O	ONFO	RMANCE / U	PDATE	QA Closed:	Date:	
Work Orde	or'∙				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root	1			Descri	tion of work order update	Initial	· ·	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	ng De	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling											
Operator	\dashv			Ì							
Material											
Setup											
Other											
Process											
Supplier											
Training			İ								
Unapproved											
					F.	AULT CA	TEGORY	.			
Landi	ng Gear				General				_		_
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ection Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped				Burrs	Instr	uctions Incomplet	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maii	ntenance		Part Moved		
	Heat Tre	eat		<u> </u>	Countersink	Misla	beled		Positioned \	Wrong	-
	Insperti	nn Strin in	Tuha	1	Cut Too Short	Micr	Power Loss	/Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	106168
Description: Eyebolt Plate	Part Number:	D3912-5
Inspection Dwg: D3912 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

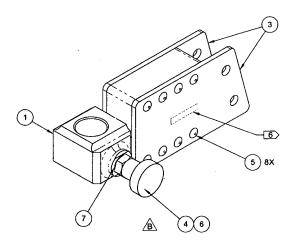
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.129"	<u>_</u>		v	Jkmoi
Ø0.257	+0.006-0.001	0.358"	-		Ü	
0.38	+/-0.030	0.384"	<u></u>		J	
1.500	+/-0.010	1.501"	~		V	
0.500 Pitch	+/-0.010	0.504"	_		ν	
3.15	+/-0.030	3.15	_		٧	
0.375	+/-0.010	0.377"	_		V	
0.517	+/-0.010	0.519	_		٧	
1.000	+/-0.010	1.003"	-		V	
3.65	+/-0.030	3.652	-		V	
1.500	+0.020/-0.000	1.209,	_		V	
0.25	+/-0.030	0.751	_		ν	
2.00	+/-0.030	2.009	_		V	
0.125	+/-0.010	0.116"	_		V	
				1		
)AS	ě.		

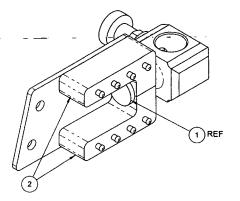
Measured by:	Jm	Audited by:	9-89	Preliminary Approval:	
Date:	13-11-5	Date:	13115	Date:	

Rev	Date	Change	Revi	sed b	у	Approved
Α	10.06.07	New Issue	KJ	1	^	1 1
В	10.08.09	Dwg Rev updated	KJ	- OK		1.2
					7	

	-		,								
	ITEM	QTY -041	P/N	DESCRIPTION							
		Х	D3912-041	EYEBOLT RECEIVER ASSY							
	1	1	D3912-1	EYEBOLT	\neg						
	2	2	D3912-3	EYEBOLT BLOCK							
	3	2	D3912-5	EYEBOLT PLATE	╗.						
D	4	1	D3801-1	SPRING PLUNGER							
	5	- 8	MS20615-4M20	-RIVET	 						
	6	1	MS21209-F615	HELICAL	\neg						
	7	1	NAS1149F0332P	WASHER	B						







SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

1001198 WCD



D3912-041 EYEBOLT RECEIVER ASSY

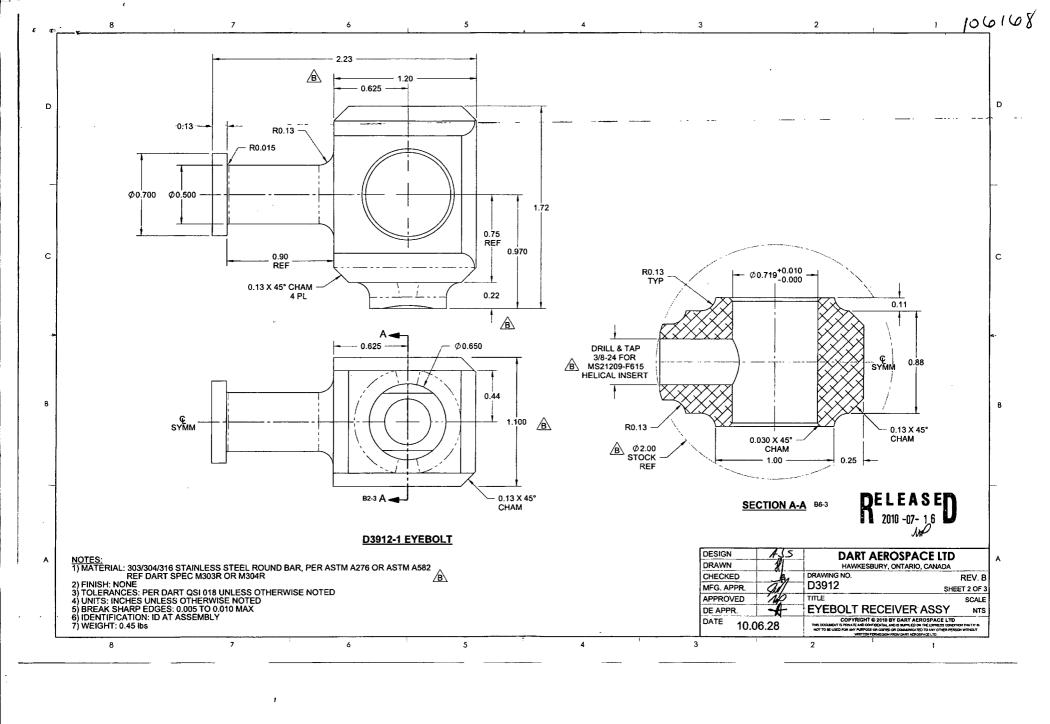
С

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0863R ADDED; BOSS ADDED TO D3912-1. 10.06.28 NEW ISSUE 10.03.04 Α JPH REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR. SHEET 1 OF 3 TITLE APPROVED SCALE **EYEBOLT RECEIVER ASSY** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THE DOCUMENT IS REVOLVE AND COMPOSITION HOLD IS SEPTEMBLO ON THE COMPOSITION HOLD IT IS NOT TO BE USED FOR ANY ARPOSE OR COMPED ON COMMANDALITY TO NAY OTHER PERSON WITHOUT WINDTH PERSONS HOLD NOT ADMINISTRATING. DATE 10.06.28

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100168 3.15 1.500 0.800+0.000 10.375 0.500 PITCH R0.13 TYP Ø0.129 THRU 1.500 4 PL 0.400 0.500 PITCH 0.25 0.517 0.50 REF 1.00 0.750+0.000 1.000 1.500+0.020 R0.13 0.500 2.00 - R0.125 0.516 +0.015 0.63 REF Ø0.129 Ø0.257 8 PL 0.125 2 PL REF **D3912-3 EYEBOLT BLOCK** 3.65 3.69 REF **D3912-5 EYEBOLT PLATE** NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B -5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA DESIGN DART AEROSPACE LTD 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3912 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE **EYEBOLT RECEIVER ASSY** DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COLUMN THE MOD CONTROL WOOD OF THE MOD COLUMN TO SHAPE OF THE COPYRIGHT OF THE MODERN AND PROPERTY OF THE MODERN DATE 10.06.28 8